

Date: Monday, 2/5/2007 8:08:46 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEBBING TIDY
 Job Number : 30614
 Estimate Number : 11381
 P.O. Number : N/A Part Number : D32153
 This Issue : 2/5/2007 S.O. No. : N/A Drawing Number : D3215 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : C
 Previous Run : 29694 Material : N/A
 Due Date : 2/9/2007 Qty: 140 Um: Each
 Written By :
 Checked & Approved By : 07.02.05
 Comment : Est. A 04.01.06 New issue KJ/RF
 Est Rev:B Now on Waterjet 06-07-03 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S040 5052-H32 .040 Sheet



Comment: Qty.: 0.0271 sf(s)/Unit Total : 3.7926 sf(s)

5052-H32 .040 Sheet

Material: 5052-H32 (QQ-A-250/8) 0.040" thick

(M5052H32S.040)

Identify for D3215-3A

Batch: M102448

SAO 07/02/18 (140)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3215

Dwg Rev: C

Prog Rev: C

SAO 07/02/18

2-Deburr if necessary

(140)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAO 07/02/18 (140)

4.0 QC8 SECOND-CHECK



Comment: SECOND CHECK

07.02.15 (140)
 C. J. L. M.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 8:08:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 30614

Part Number: D32153

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M5052H32S040

5052-H32 .040 Sheet



Comment: Qty.: 0.0084 sf(s)/Unit Total: 1.1760 sf(s)

5052-H32 .040 Sheet

Batch: M101875

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut blank: 2.130" x 0.530"

mf. 07-02-20

(140)

2-Deburr

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/02/20

(140)

8.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form D3215-3A as per Dwg D3215

SB 07/02/20

(140)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/02/23

(140)

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004

A/R AL ROD BATCH: M102756

Identify as D3215-3

Grind flush

Cpl 07-03-01

(140)

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SB 07/03/01

(140)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: De Date: 07/03/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 8:08:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 30614

Part Number: D32153

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/01 (140)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL/M-R

07/03/02

(140)

14.0

POWDER COATING

POWDER COATING



M100700



(140)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-R

07/03/02

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C 07/03/05

(139)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

C 07/03/05

(139)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/05

(139)

Job Completion



U 07.0305

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

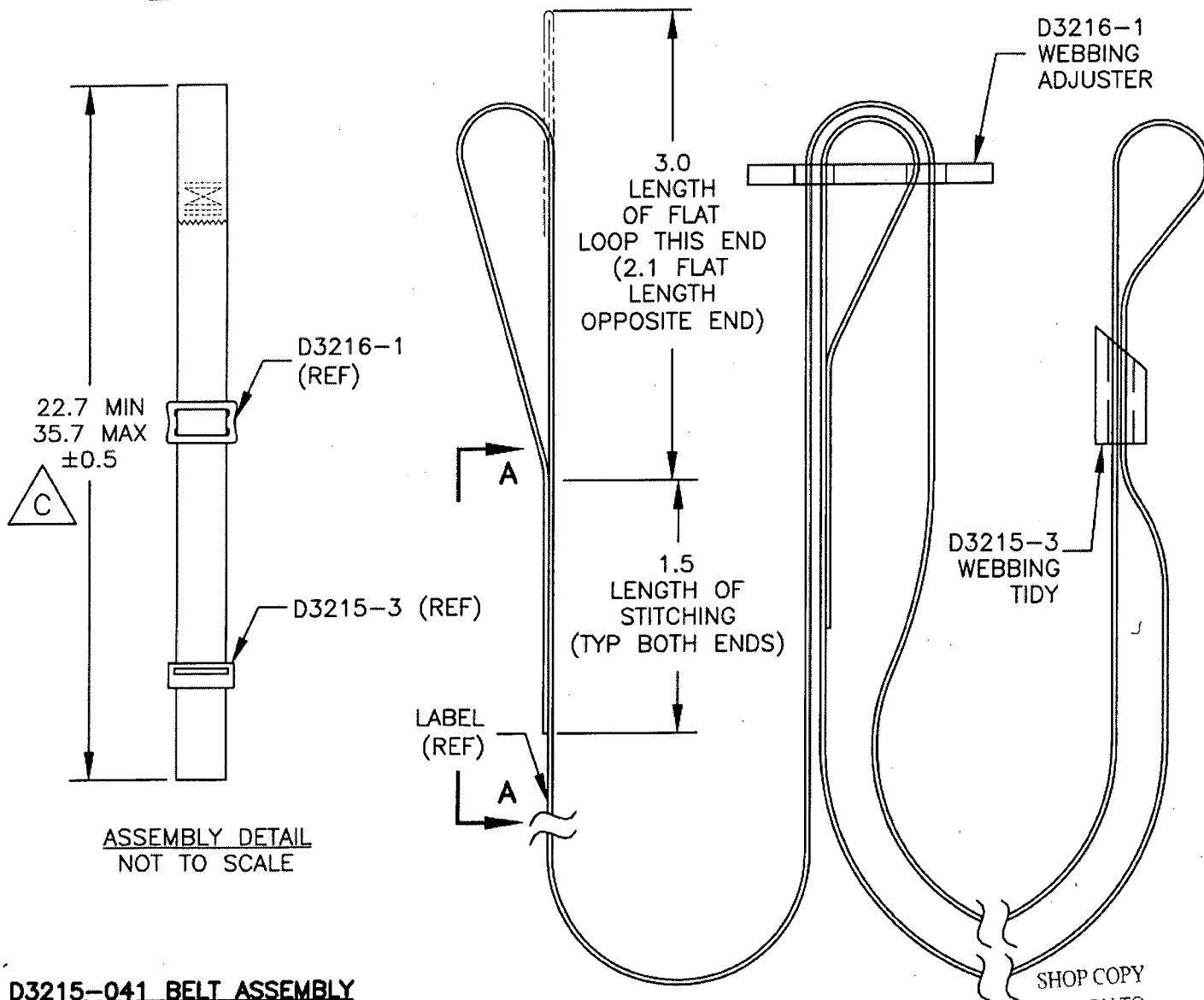
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	APPROVED	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3215	REV. C SHEET 1 OF 3
DATE 04.03.05	TITLE BELT ASSEMBLY		SCALE NTS
A	03.09.19	NEW ISSUE	
B	04.01.12	AS MANUFACTURED; ADD TOLERANCE	
C	04.03.05	REDUCE LENGTH; CLARIFY STITCHING	

RELEASED
04.03.08



D3215-041 BELT ASSEMBLY

- MATERIAL: WEBBING = LAGRAN CANADA INC. 26472
(2" WIDE x 0.060" THICK BLACK POLYESTER WEBBING, CERTIFIED TO FAR 29.853A3, TENSILE STRENGTH 5700 lb MIN)
THREAD = VT 295 TYPE II CLASS A SIZE 3, BLACK NYLON THREAD
LABEL = TYVEK
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WORK ORDER
NO. 30614

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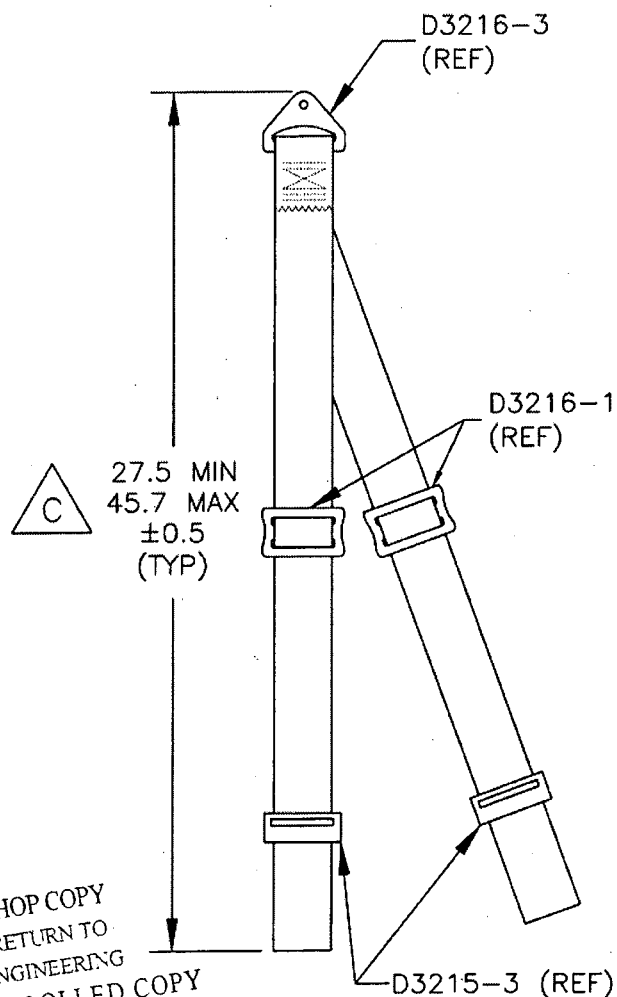
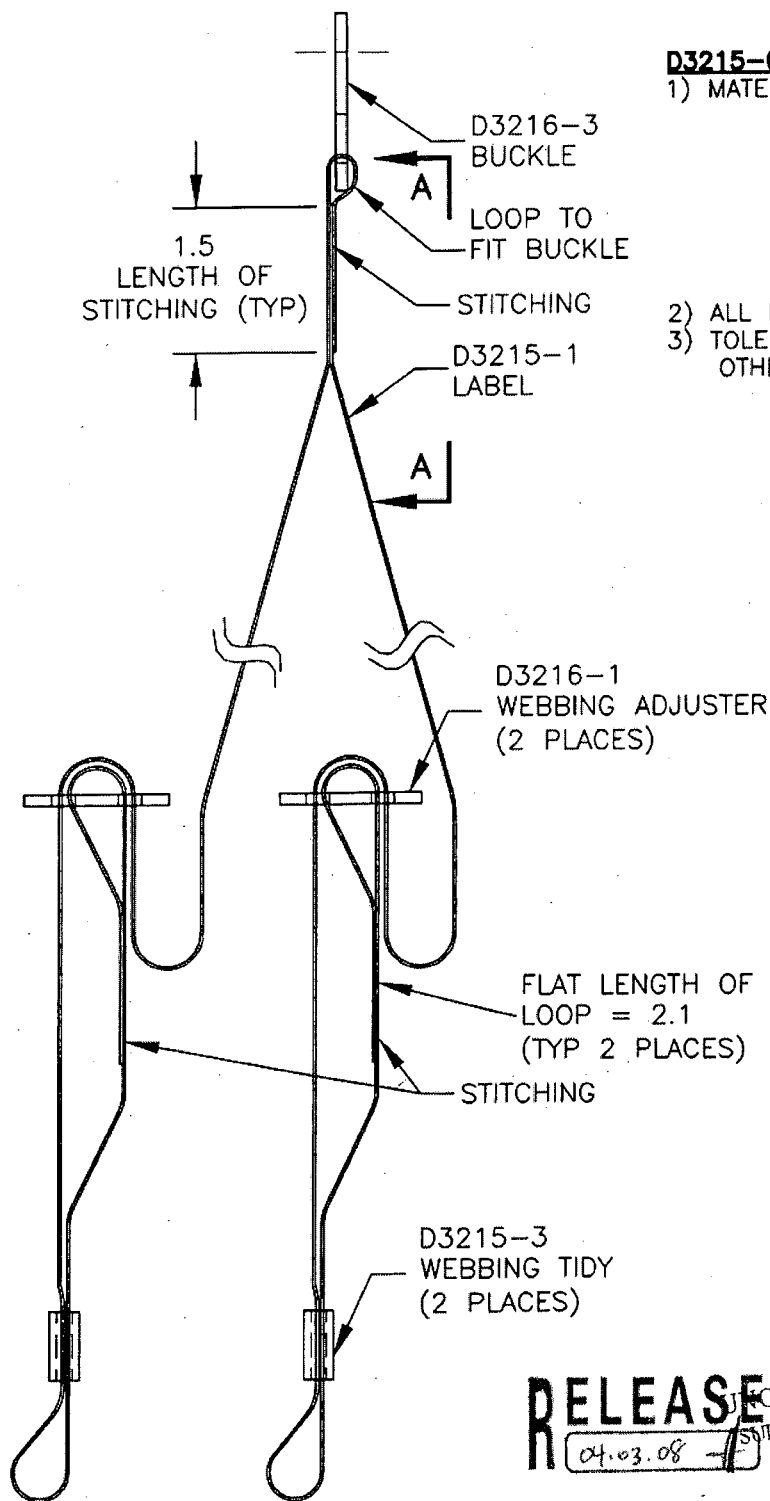
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DESIGN UP	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3215	REV. C SHEET 2 OF 3
DATE 04.03.05	TITLE BELT ASSEMBLY		SCALE NTS

D3215-043 BELT ASSEMBLY

- 1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472
(2" WIDE x 0.060" THICK
BLACK POLYESTER WEBBING,
CERTIFIED TO FAR 29.853A3,
TENSILE STRENGTH 5700 lb MIN)
THREAD = VT 295 TYPE II CLASS A SIZE 3,
BLACK NYLON THREAD
LABEL = TYEK
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED.



RELEASED
04.03.08

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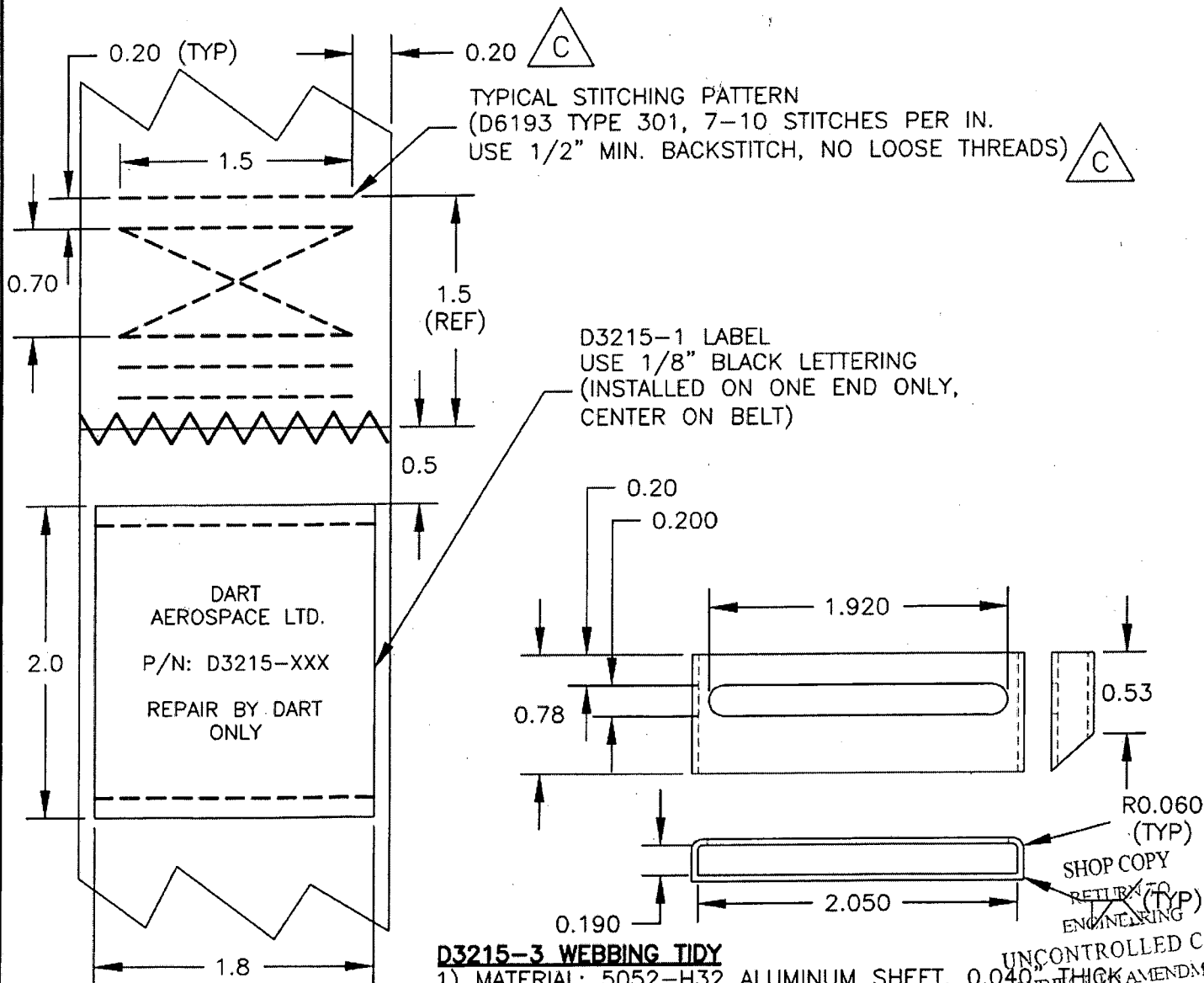


DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3215	REV. C SHEET 3 OF 3
DATE 04.03.05	TITLE HARNESS ASSEMBLY		SCALE 1:1

VIEW A-A

XXX = 041 FOR D3215-041

XXX = 043 FOR D3215-043



D3215-3 WEBBING TIDY

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.040" THICK
(REF DART SPEC. M5052H32S.040)
- 2) WELD PER DART QSI 004
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED

RELEASED
04.03.08

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